

Date: Tuesday, 5/13/2008 9:08:18 AM  
 User: Chantal Lavoie

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services			<b>Drawing Name</b>	: SEAL		
<b>Job Number</b>	: 39182			<b>Part Number</b>	: D31169		
<b>Estimate Number</b>	: 10085			<b>Drawing Number</b>	: D3116 REVA		
<b>P.O. Number</b>	:			<b>Project Number</b>	: N/A		
<b>This Issue</b>	: 5/13/2008	<b>S.O. No.</b>	:	<b>Drawing Revision</b>	: A		
<b>Prsh Rev.</b>	: NC			<b>Material</b>	:		
<b>First Issue</b>	: / /	<b>Type</b>	: PURCHASED PARTS	<b>Due Date</b>	: 6/30/2008	<b>Qty:</b>	500
<b>Previous Run</b>	: 39182			<b>Um:</b>	F		
<b>Written By</b>	:			<b>Comment</b>	: Est. A: 02.05.15 New Issue NG		
<b>Checked &amp; Approved By</b>	:						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		 <b>Comment:</b> PURCHASING Issue P/O: <u>6350</u> <i>C 08/05/13</i> Seal as per dwg D3116 Possible Supplier: Accurate rubber / Minor rubber P/N ZX1267( replaces P/N ZX1267 ) Material release note required
2.0	ZX1267	SEAL
		 <b>Comment:</b> Qty.: 500.0000 f(s)/Unit Total : 250000.0000 f(s) Seal ZX1267
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		 <b>Comment:</b> PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached <i>18 08/07/23 (x500)</i>
4.0	QC6	DIMENSIONAL CHECK
		 <b>Comment:</b> DIMENSIONAL CHECK Check dims to dwg and certification attached <i>8 08/07/23 (x500ft)</i>
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		 <b>Comment:</b> PACKAGING RESOURCE #1 Identify and Stock Location: <u>SDY08</u> <i>C 07/23 (500)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 5/13/2008 9:08:18 AM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAL

Job Number: 39182

Part Number: D31169

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/07/24 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>4</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>CP</i>	DRAWING NO. D3116	REV. A SHEET 1 OF 1
DATE 02.04.15		TITLE SEAL	SCALE NTS
A	02.04.15	NEW ISSUE	

D3116-1-XXXX SEAL (REPLACES P/N 110-004-2)

WHERE XXXX IS LENGTH IN TENTHS OF INCHES

EG. 87.5" LONG = D3116-1-0875

10" LONG = D3116-1-0100

POSSIBLE SUPPLIER: AERO PRODUCTS COMPONENT SERVICES

P/N: 110-004-2 SEAL

COLOR: BLACK

D3116-3-XXXX SEAL (REPLACES P/N 110-160-1)

WHERE XXXX IS LENGTH IN TENTHS OF INCHES

EG. 87.5" LONG = D3116-3-0875

10" LONG = D3116-3-0100

POSSIBLE SUPPLIER: AERO PRODUCTS COMPONENT SERVICES

P/N: 110-160-1 SEAL

COLOR: WHITE

D3116-5-XXXX SEAL (REPLACES P/N 110-031-4 & 110-031-2)

WHERE XXXX IS LENGTH IN TENTHS OF INCHES

EG. 87.5" LONG = D3116-5-0875

10" LONG = D3116-5-0100

POSSIBLE SUPPLIER: AERO PRODUCTS COMPONENT SERVICES

P/N: 110-031-4 SEAL, BLACK

D3116-7-XXXX SEAL (REPLACES P/N ZX2054)

WHERE XXXX IS LENGTH IN TENTHS OF INCHES

EG. 87.5" LONG = D3116-7-0875

10" LONG = D3116-7-0100

POSSIBLE SUPPLIER: ACCURATE RUBBER/MINOR RUBBER

P/N: ZX2054 SEAL

D3116-9-XXXX SEAL (REPLACES P/N ZX1267)

WHERE XXXX IS LENGTH IN TENTHS OF INCHES

EG. 87.5" LONG = D3116-9-0875

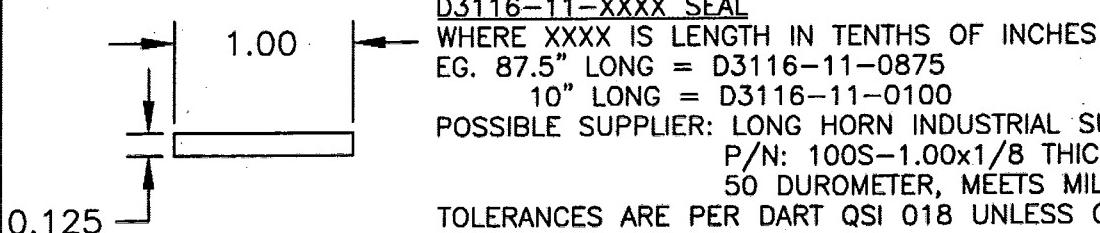
10" LONG = D3116-9-0100

POSSIBLE SUPPLIER: ACCURATE RUBBER/MINOR RUBBER

P/N: ZX1267 SEAL

**RELEASED**

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 3918



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DART AEROSPACE  
1270 ABERDEEN STREET  
HAWKESBURY ONTARIO K6A-1K7 CANADA



Customer # 1000369

Attn: Chantal  
Phone: (613) 632-9577 Fax: (613) 632-1053  
Email: clavoie@dartaero.com

# QUOTATION 241701

LEVEL 1 Quotation has been changed

DATE May 12, 2008

CUST REF: Verbal

VALID UNTIL: 7/11/08

TERMS: NET 30 DAYS

FOB: ORIGIN "(See Below)"

QUOTED BY: DeeDee Brave

# Minor Rubber Co., Inc.

49 Ackerman Street  
Bloomfield, NJ 07003  
Phone: (973) 338-6800  
Fax: (973) 893-1399

## STANDARD DIMENSIONAL TOLERANCE TABLE - MOLDED RUBBER PRODUCTS DRAWING DESIGNATION "A3" COMMERCIAL

Size (Millimeters)	Fixed	Closure	Size (Inches)	Fixed	Closure
Above Incl.			Above Incl.		
0 - 10	+/- .20	+/- .32	0 - .40	+/- .008	+/- .013
10 - 18	.26	.40	.40 - .63	.010	.016
18 - 26	.32	.50	.63 - 1.00	.013	.020
26 - 40	.40	.63	1.00 - 1.60	.016	.025
40 - 63	.50	.80	1.60 - 2.50	.020	.032
63 - 100	.63	1.00	2.50 - 4.00	.025	.040
100 - 180	.80	1.25	4.00 - 8.30	.032	.050
180 - & over			8.30 & over		

FIGURE 1

Tolerances for outside (O.D.) diameters, inside (I.D.) diameters, wall thickness, width, height and general cross sectional dimensions of extrusions.

RMA Class	Precision
Drawing Designation	E2
Dimensions (in Millimeters)	
Above	Up to
0	1.6
1.6	2.5
2.5	4.0
4.0	6.3
6.3	10
10	16
16	25
25	40
40	63
63	100

RMA Class	Precision
Drawing Designation	E2
Dimensions (in Inches)	
Above	Up to
0	0.06
0.06	0.10
0.10	0.16
0.16	0.25
0.25	0.40
0.40	0.63
0.63	1.00

Tolerances for outside (O.D.) diameters, inside (I.D.) diameters, wall thickness, width, height and general cross sectional dimensions of extrusions.

Schedule 1  
Cross Sectional Tolerances

COMMERCIAL				
RMA - CLASS 2 - DWG DESIGNATION A2				
0.00 - 0.10*	+/- .013	(0 - 3/32)	0.0 - 2.5*	+/- .32
0.10 - 0.16	.016	(3/32 - 5/32)	2.5 - 4.0	.40
0.16 - 0.25	.020	(5/32 - 1/4)	4.0 - 6.3	.50
0.25 - 0.40	.025	(1/4 - 13/32)	6.3 - 10.0	.63
0.40 - 0.63	.032	(13/32 - 5/8)	10.0 - 16.0	.80
0.63 - 1.00	.040	(5/8 - 1)	16.0 - 25.0	1.00

Use +/- 3 - 1/2 % for dimensions over 1.00 inch

Schedule 2  
Cross Sectional Tolerances

COMMERCIAL				
RMA - CLASS 2 - DWG DESIGNATION A2				
0.00 - 0.10*	+/- .018	(0 - 3/32)	0.0 - 2.5*	+/- .40
0.10 - 0.16	.020	(3/32 - 5/32)	2.5 - 4.0	.50
0.16 - 0.25	.025	(5/32 - 1/4)	4.0 - 6.3	.63
0.25 - 0.40	.030	(1/4 - 13/32)	6.3 - 10.0	.80
0.40 - 0.63	.040	(13/32 - 5/8)	10.0 - 16.0	1.00
0.63 - 1.00	.050	(5/8 - 1)	16.0 - 25.0	1.25

Use +/- 4 - 1/2 % for dimensions over 1.00 inch

Note: There is a relationship between hardness and the amount of tolerance which will be used.

The lower the hardness the more tolerance necessary.

\* General cross sectional dimensions below 0.040" (1mm) are impractical.

FIGURE 2

Note: Tolerances on dimensions above 100 mm (3.94) should be agreed on by supplier and user. General cross sectional dimensions below 1 mm (0.04) are impractical. In general, softer materials and those requiring a post cure need greater tolerance.

FIGURE 3

DART AEROSPACE  
1270 ABERDEEN STREET  
HAWKESBURY ONTARIO K6A-1K7 CANADA



# QUOTATION

241701

Quotation has been changed

LEVEL 1  
DATE May 12, 2008  
CUST REF: Verbal  
VALID UNTIL: 7/11/08  
TERMS: NET 30 DAYS  
FOB: ORIGIN "(See Below)"

May-12-08 04:04pm

From-Minor Rubber Co.

Customer # 1000369

Attn: Chantal  
Phone: (613) 632-9577 Fax: (613) 632-1053  
Email: clavoie@dartaero.com

# Minor Rubber Co., Inc.

49 Ackerman Street  
Bloomfield, NJ 07003  
Phone: (973) 338-6800 Fax: (973) 893-1399

QUOTED BY: DeeDee Brave

ITEM	DESCRIPTION	MR PART #	QUANTITY	PRICE / UNIT
1	EPDM Durometer 70 CHOCALATE BR  P/N D3116-9 REF* MR Style # ZX-1267 8 FT +/- .250" STRAIGHT LENGTHS DWG SK-22894-MH RMA CLASS 2 SCHEDULE 2 CROSS SECTION TOLERANCES APPLY Country USA This Line Item is subject to +10.00% / -10.00 % variations in Quantity. Delivery 6 To 8 Weeks Quality Notes Exception Notes RMA Class 2 Schedule 1 Commercial Tolerances apply for all cross-sectional dimensions where a lesser tolerance or no tolerance is stated for subject item(s)	380840 - 0	500 1,000	1.71 / Ft 1.54 / Ft

## General Notes

SHIPPING: Unless otherwise specified, shipments will be made via UPS or Motorfreight, Collect, against your account number.  
F.O.B. Origin (Bloomfield, NJ or Carrollton, TX) at Minor Rubber's option.  
Subject to Minor Rubber's standard terms and conditions, available on request.  
All Durometers to be Shore 'A' and +/- 5, unless otherwise specified.



## Minor Rubber Co., Inc.

49 Ackerman Street  
Bloomfield, NJ 07003  
Phone: (973) 338-6800

Fax: (973) 893-1399

Customer# 1000369  
MR Vend ID# 1

Page 1 of 1

**DART AEROSPACE**  
1270 ABERDEEN STREET  
HAWKESBURY ONTARIO K6A-1K7 CANADA

**B** Dart Aerospace  
**I** 1270 ABERDEEN STREET.  
**L** HAWKESBURY ONTARIO K6A-1K7 CANADA  
**L**

### Attention:

Chantal  
Phone: (613) 632-9577  
Fax: (613) 632-1053  
clavoie@dartaero.com

## Order Confirmation 16939

Level	4	Order has been change
Cust PO	P000006350	
Order Date	5/14/08	
Terms	Net 30 Days	

**Dart Aerospace**  
1270 ABERDEEN STREET  
HAWKESBURY ONTARIO K6A-1K7 CANADA

### **M** Dart Aerospace

**A** 1270 ABERDEEN STREET.  
**I** HAWKESBURY ONTARIO K6A-1K7 CANADA  
**L** Phone: 999 999-9999 Fax: 999 999-99

Item	Description					Cus-Sched	Required	Promised	QTY Ord	Ship Via
1	Cust Line# 1	EPDM Durometer 70 CHOCALATE BROWN		Cust Part# D3116-9						
	MR Part# 380840-0				Value \$855.00					
	QTY 500 FT	Price 1.71								
	DWG / REV / EC D3116 / A									
	MR_Style # ZX-1267									
	8 FT +/- .250" STRAIGHT LENGTHS									
	RMA CLASS 2 SCHEDULE 2 CROSS SECTION TOLERANCES APPLY									
	Country USA									
	This Line Item is subject to NO variations in Quantity									
	Quality Notes									
	Exception Notes									
	Quote # 241701	Quote Line 1								
	RMA Class 2 Schedule 1 Commercial Tolerances apply for all cross-sectional dimensions where a lesser tolerance or no tolerance is stated for subject item(s)									

Ship Via	Description	Service	Billing Type	FOB
10,421	FEDEX	I Eco	Coll	Origin

### General Notes:

FOB, Origin (Bloomfield, NJ or Carrollton, TX) at Minor Rubber's option.

This Order is Subject to Minor Rubber's standard terms and conditions, available on request.

All Durometers to be Shore 'A' and +/- 5 unless otherwise specified.

Tolerance Exemptions as stated in each associated quote, respectively.

S  
08/08/08